

Date: Monday, 18/08/2008 4:03:32 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CAP		
Job Number	: 41340			Part Number	: D2855		
Estimate Number	: 10519			Drawing Number	: D2855 REV. A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 18/08/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: 18/08/2008 Type : PURCHASED PARTS			Due Date	: 15/09/2008 Qty: 25 Um: Each		
Previous Run	: 39562						
Written By	:						
Checked & Approved By	: <u>2008.8.18</u>						
Comment	: Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: <u>6979</u> <i>C208/08/19</i> Cast per Dwg D2855 Material Release Note Required <i>(25)</i>
2.0	D2855P	Cap
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s) CAP
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <i>(20)</i>
4.0	QC6	DIMENSIONAL CHECK
		 <i>QC6/08/28 (20) Coated</i>
		Comment: DIMENSIONAL CHECK <i>S08/08/28 XZS</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <i>EP08/09/10 (25)</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 41340		Part Number: D2855
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP
7.0	POWDER COATING	POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: <u>1:30</u> OVEN TEMPERATURE: <u>320</u> FINISH TIME: <u>2:00</u>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT
9.0	ALS7-1032225	INSERT Comment: Qty.: 2.0000 Each(s)/Unit Total: 50.0000 Each(s) INSERT Pick: Qty Part Number Description Batch 2 ALS7-1032-225 Insert <u>ALS7-1032-225</u> or AKS7-1032-225 or ALS4-1032-225 or AKS4-1032-225
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Install Inserts as per Dwg D2855
11.0	QC5	INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP
12.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>FP-7</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

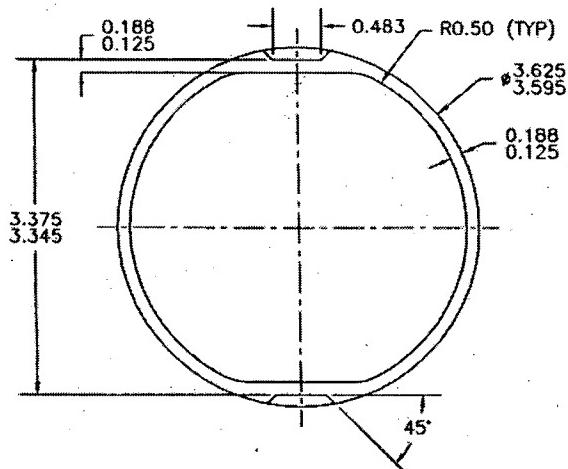
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

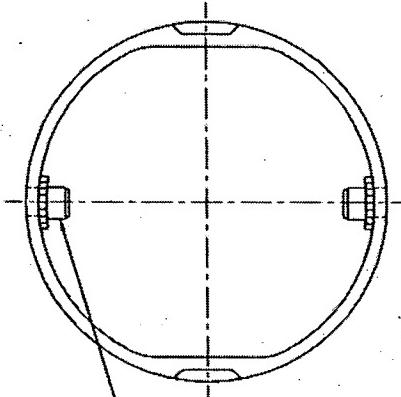
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

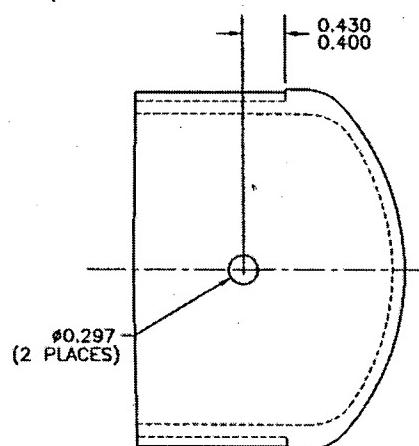
D2855 CASTING DETAIL



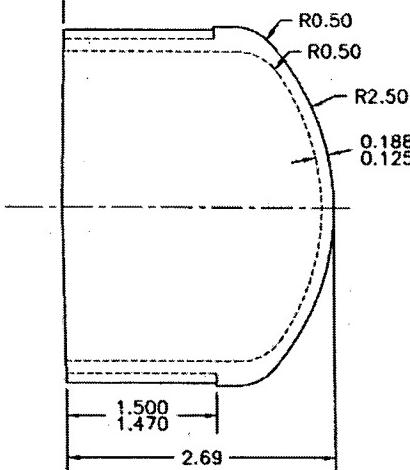
D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)



1° TAPER



RELEASED
98.12.14 DS

DART

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. A	SHEET 1 OF 1
<i>JP</i>	<i>KE</i>	D2855		
DATE		TITLE		SCALE
98.12.12		CAP		NTS
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)		

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47240

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 43 KG 99.09.12
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

7 CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTD
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à Shipped	DART AEROSPACE	A.F. & P.W. Série no./Serial no.
	1270 Aberdeen Street	Packing Date: 26/08/2008 Slip No. 32689
	Hawkbury, ON, K6A 1K7	Votre No. Commande 00006979 Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificates di détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Note No. Our No.	Specifications	Note d'autorisation Incoming Release note
25	D 2855 CAP	Z098046	A366.2	ingot#851118 <i>OEL/OCVZS</i>

Analysse
Analysis (as in ingot)

(Si)	7.80%	(Al)	balance
(Fe)	0.06%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.42%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donne Yield :	Résistance à la tension : Tensile Strength :	Allongement par pouce carré : P.S.I. Elongation : %
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Pour et au nom de
For and on behalf of:

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTD
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :
Par/Per :

Coc-100

Aluminum Foundry Ltd

714-716 Calais
Dorval, Québec H9P 2P3
Tel: (514) 631-1331
Fax: (514) 631-8448

Packing Slip

Packing Slip No.: 32689
Date: Aug 26, 2008
Page: 1

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7	DART AEROSPACE 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7
Order No.: PO00006979	Sold By:
Shipped By: FEDEX 157193240	Ship Date: Aug 26, 2008
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	25
<i>1 CofC</i> <i>08/08/28</i>			
Comment:			